

Work Order ID 157560

Monday, March 13, 2017 8:58:38 AM

157560

Page 1

Item ID: D3916-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Rib
 Start Date: 3/16/2017 Start Qty: 9.00 ***9*** Cust Item ID:
 Required Date: 3/20/2017 Req'd Qty: 9.00 ***9*** Customer:
 Reference: SCHEDULED

Approvals: Process Plan: DAS 21 9-89 Date: MAR 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3916	A

100

0.00

100

Large Fab

Large Fab

Memo

0.51

1- Cut tube 50"
 2- Bend tube with manuel pipe bender as per DT9566
 *** Make line at 9.00" annd use jig for other line***
 3- Trim access tube material to finish size as per dwg D3916

9x DG 2017/03/13

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

Memo

0.00

9x DAS 24 9-89 MAR 14 2017

120

Identify as per dwg & Stock Location: W/A 004

0.00

120

Packaging

Packaging

Memo

0.02

LOCATION: WA004

9x CC 17-3-14

Work Order ID 157560***157560***

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.15							
Quality Control									

MAR 14 2017

Picklist Print

Page 1

Monday, March 13, 2017 8:58:42 AM

Work Order ID: 157560

157560

Parent Item: D3916-5

D3916-5

Parent Item Name: Light Rib

Start Date: 3/16/2017

Required Date: 3/20/2017

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	1,043.146	4.166	39.46737			
M304TS0 500W 049									**			2017/03/13	
Square Tubing													

Location

WA004

Loc Qty

1043.14684

624

23.64684

395.5

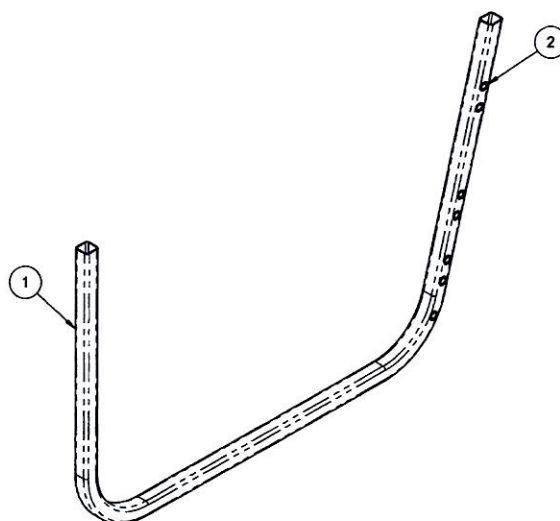
Loc Code

~~813698~~

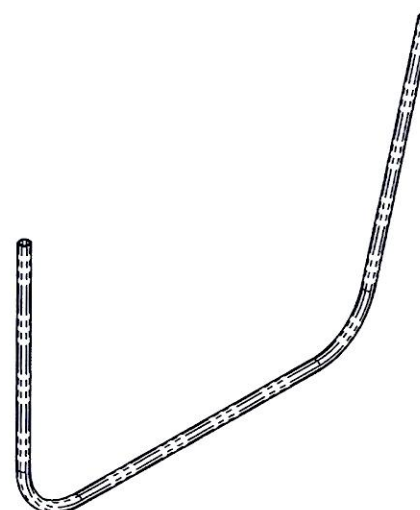
B136698 =>

45

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157560 MOS

1703-13

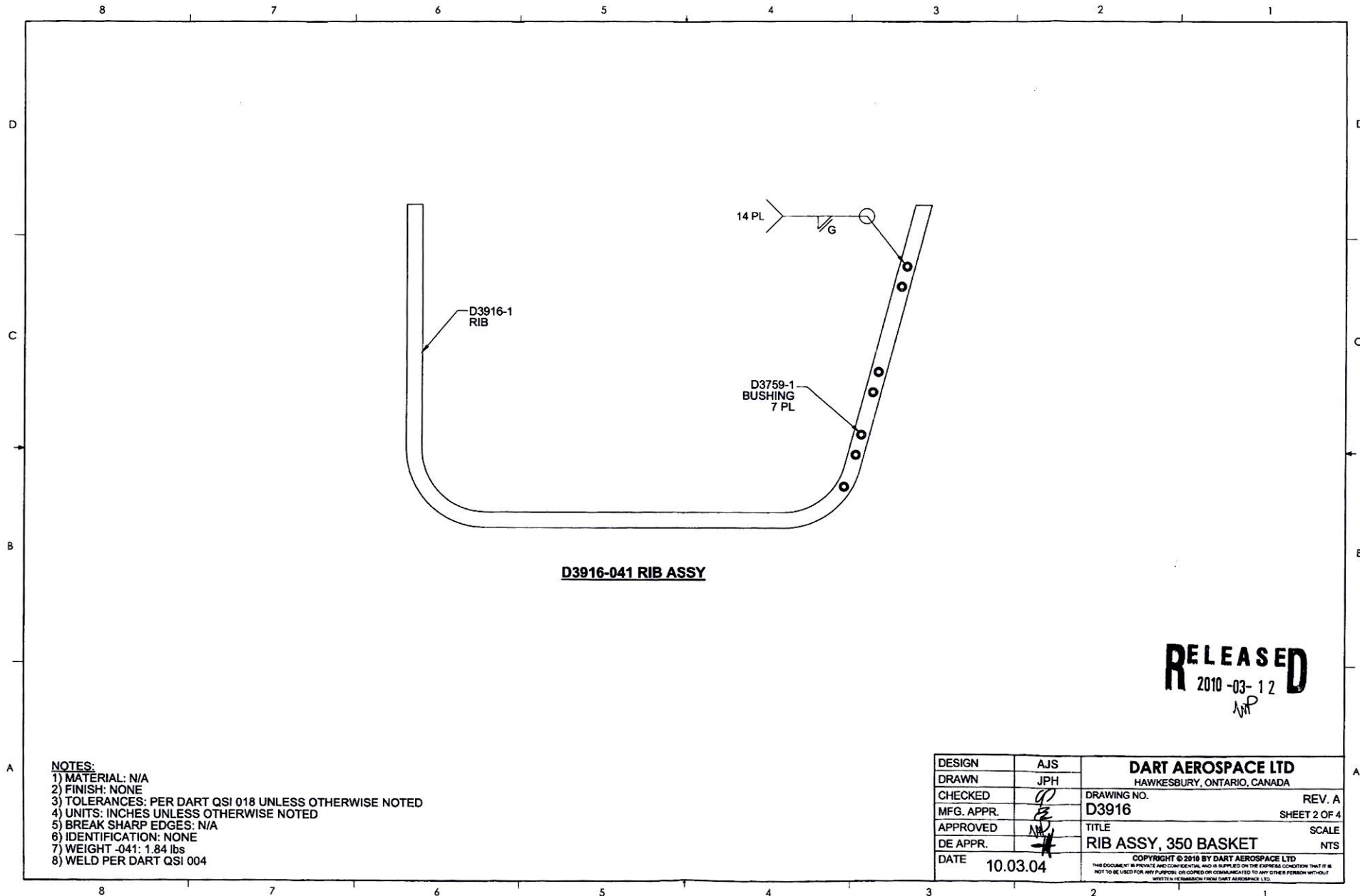
OK 10.12.21
UNDER REVIEW

ADDITION OF HOLE + BUSHING
on D3916-041-1 RIBS.

RELEASED

2010-03-12

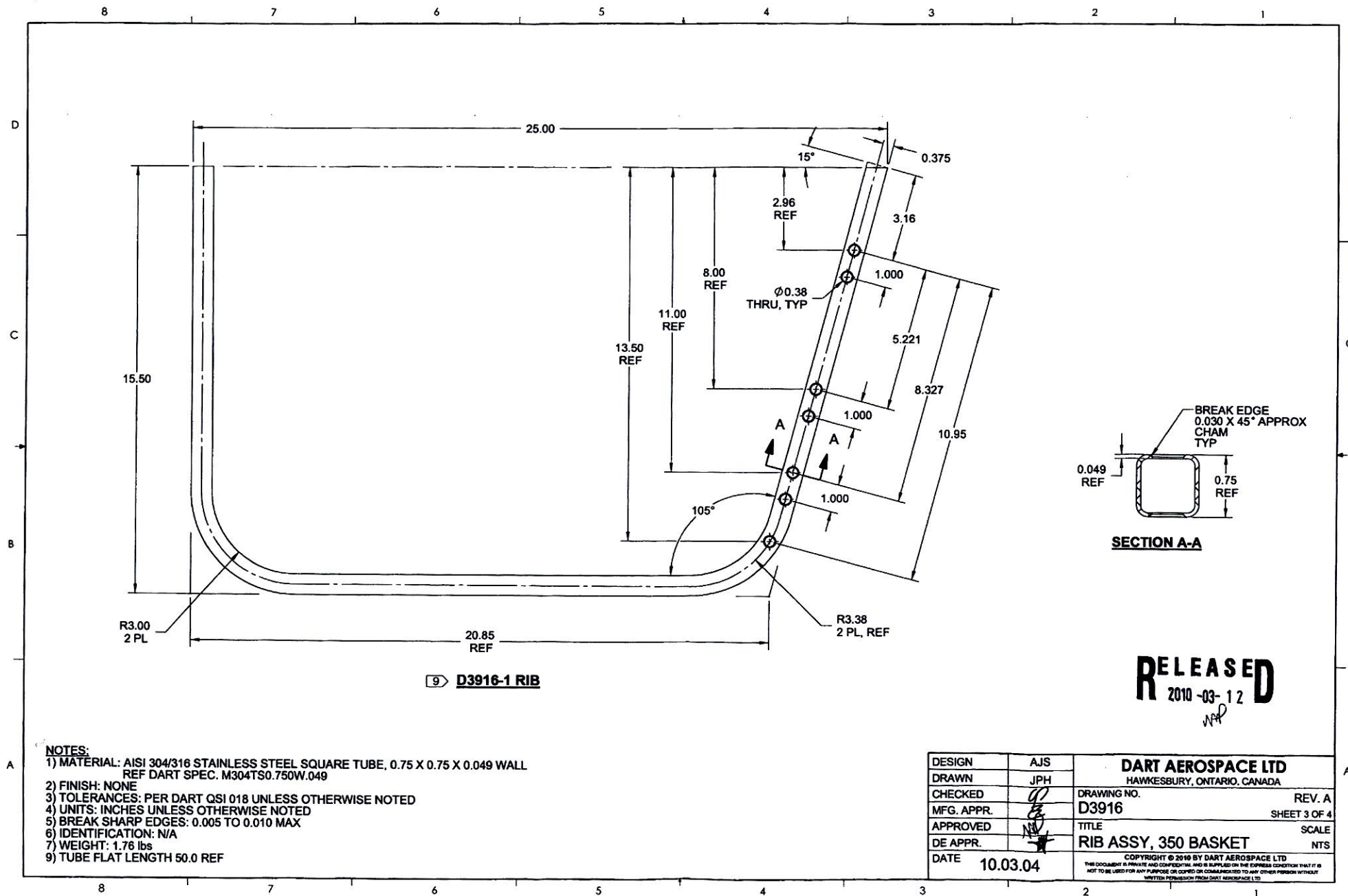
A	NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3916	SHEET 1 OF 4
APPROVED			TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET		NTS
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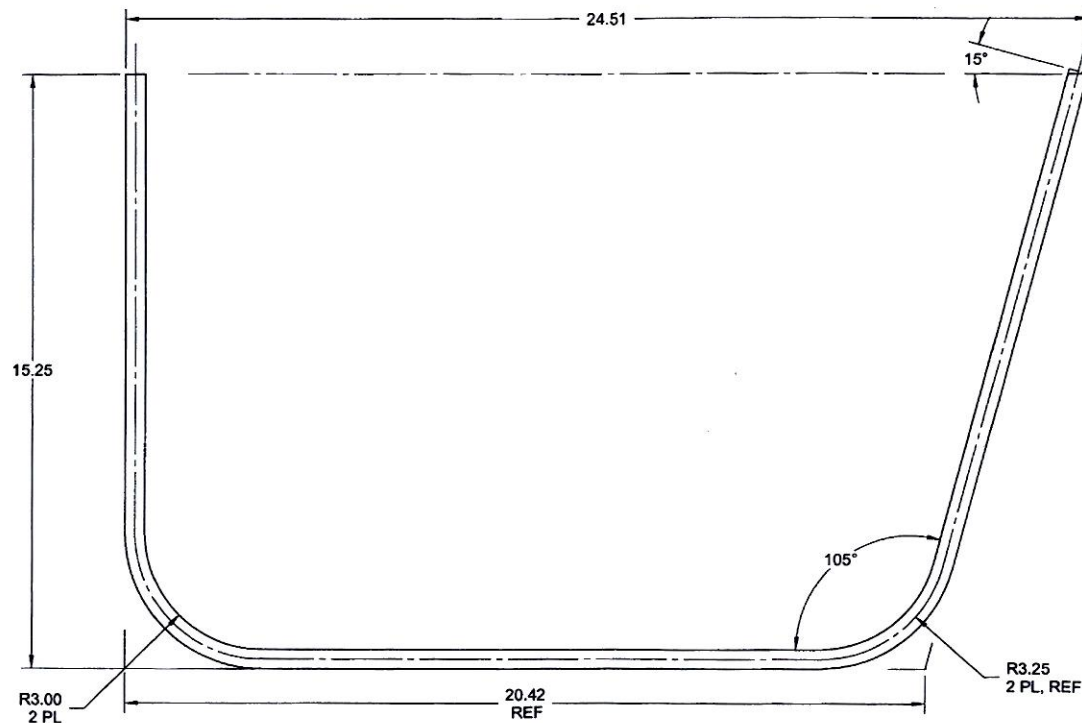


RELEASED
2010-03-12
JNP

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT -041: 1.84 lbs
 8) WELD PER DART QSI 004

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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9 D3916-5 LIGHT RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

RELEASED
2010-03-12
JMP

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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